



Dart Hawkesbury
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D4634-143
Job Sheet 167077-C



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	2017-12-14 JSC
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	17/01/19 JSC
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	17/01/19 JSC
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	PD. DEC 21 2017
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 138649 Expiry Date 18/01/19 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-3 <u>5021652</u>	1	2	0	0
	- D4636-5 <u>5021651</u>	2	43	0	0
	- D4647-1 <u>5021650</u>	1	4	0	0
	- D4664-5 <u>5021649</u>	6	39	0	0
	- D4712-1 <u>5021648</u>	2	4	0	0
	- D4732-21 <u>5021647</u>	1	6	0	0
	- D4732-25 <u>5021646</u>	1	7	0	0
	- D5021-3 <u>5021645</u>	1	2	0	0
	- MPNY-750S-9-C <u>5021644</u>	3	570	0	0
	- MS20426AD3-4 <u>5021643</u>	4	5,055	0	0
	- MS20426AD4-6 <u>5021642</u>	4	2,797	0	0
	- MS21059L08 <u>5021641</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date: _____	DISPOSITION Mfg Date: 12/14/17 Job No: 167077 - C D4634 - 143 Start up Operation	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;"> Skid-tube ☐ Machining ☐ forming ☐ Large Fab ☐ </td> <td style="width: 25%;"> Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 25%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 25%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table> QTY Effective : _____ Disposition MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	Skid-tube ☐ Machining ☐ forming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐		
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DART
 AEROSPACE
S021702

Middle, Center Ceiling Replacement Panel Assembly

PART NO:
Revision:
Operation:
Change No: